

Route Revised
Cmt

Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBST1009-3
Job Sheet 173629



Part No: RBST1009-3

Job Qty: 10 ea

Part Name: Retainer



Part Weight: 0 lbs

Status: Scheduled

Priority: High

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/19/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST1009 THRU 1020 Rev 7 IPP Rev A 18.03.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea	3/19/18	3/19/18	0.00	0.00	Start Up Machining-3		
110	CNC Lathe	10 pcs	3/19/18	3/19/18	0.00	5.00	MORI SL-154		
120	QC	10 pcs	3/19/18	3/19/18	0.00	0.00	QC2 Machining-4		
135	Mill Conv	10 pcs	3/19/18	3/19/18	0.00	0.00	Mill Conv 1		
145	QC	10 pcs	3/19/18	3/19/18	0.00	0.00	QC2 Machining-4		
150	QC	10 pcs	3/19/18	3/19/18	0.00	0.00	QC8 Machining-4		
180	Packaging	10 pcs	3/19/18	3/19/18	0.00	0.00	Packaging3-1		
190	QC21-SA	10 Ea	3/19/18	3/19/18	0.00	0.00	QC21		

Part Op 110 - 1-Machine as per DWG. FB937 FOLIO REV: _____ DWG REV: _____ 2-Deburr
Descriptions: 135 - 1-Machine as per DWG. 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R1.500	Bronze C63000 Round Bar 1.500"	.2100 ft (.021 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R1.500	0	3	0

Part Specifications

Specifications could not be found.

Plex 4/20/18 10:35 AM Dart.Gagnon.Michelle



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RBST1009-3
Job Sheet 173629



Part No: RBST1009-3

Job Qty: 10 ea

Part Name: Retainer



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 3/6/18

Job Tracking No:

Due Date: 3/16/18

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBST1009 THRU 1020 Rev 7 IPP Rev A 18.03.01 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	10 Ea		3/15/18	0.00	0.00	Start Up Machining-3		SL 18-4-7
110	CNC Lathe	10 pcs		3/16/18	0.00	5.00	MORI SL-154		SL
120	QC	10 pcs		3/16/18	0.00	0.00	QC2 Machining-4		SL
130	QC	10 pcs		3/16/18	0.00	0.00	QC8 Machining-4		
180	Packaging	10 pcs		3/16/18	0.00	0.00	Packaging3-1		
190	QC21-SA	10 Ea		3/16/18	0.00	0.00	QC21		

Part Op Descriptions: 110 - 1-Machine as per DWG. FB 937 FOLIO REV: _____ DWG REV: _____ 2-Deburr

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
MT-BRONZE-C63000-R1.500	Bronze C63000 Round Bar 1.500"	.3200 ft (.032 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	MT-BRONZE-C63000-R1.500	0	3	0

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-26

Part Specifications

Specifications could not be found.



Container No: S059080



Part: RBST1009-3

Job No: 173629

Serial No/Batch: S059080

Revision: 7

Inspector:

Dart Aerospace Ltd.
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Plex 3/6/18 9:02 AM Dart.lajeunesse.marie

Date: 04/09/18

Proven revision
to
Shan Marie or Michelle

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: <u>173629</u> Part No. <u>R1BST1009-3</u> NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date: _____		Step #: _____		QTY Effective: _____			MRB (QSI042) Approval <u>[Signature]</u>		
Description Work Order Deviation IT IS AS FIXTURE TOOLING HOWE IS REQUIRED TO PREVENT R1BST1009-3 FROM ROTATING DURING MACHINING				Disposition IT IS ACCEPTABLE TO DRILL UP TO QTY(1) Ø0.136 HOWE, 0.37" FROM LH TO PREVENT FIXTURES HOWE MUST BE 60° BETWEEN COUNTERBORES THIS DEVIATION IS ACCEPTABLE				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval	
Root Cause Environment ☐ Design ☒ Dwg/Data ☐ Equip/Tooling ☐ Handling/Pre ☐ Material ☐ Internal Transport ☐ Tribal Knowledge ☐ LOA ☐ Substation ☐ Past Expiry Date ☐ Misidentified ☐ No Re-verification ☐ Operator ☐ Offset/Setup ☐ Supplier ☐ Training ☐ Use for Testing ☐ Poor Information ☐ Rushing ☐ Product Improvement ☐ Process Improvement ☐ ☒ Manufacturing Process Past Due ☐		FAULT CATEGORY Pressure/Forced ☐ Bending ☐ Centre Not Concentric ☐ Cracks ☐ Crimp/Kink/Ripple/Wave ☐ Cuffs ☐ Crushing ☐ Heat Treat ☐ Wave/Twist in Tube ☐ Marks/Chatter ☐ Temperature/Cure ☐ Set-up ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Inspection Incomplete/Unqualified ☐ Contamination ☐ Countersink ☐ Cut Too Short ☐ Instructions Incomplete/Unclear ☐ Drill Holes ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set ☐ Misabeled ☐ Fit/Function ☐ Misaligned/off center ☐ Positioned Wrong ☐ Outside Dimensions ☐ Over/Under tolerance ☐ Part Incorrect ☐ Part Lost/Missing ☐ Part Moved ☐ Drawing ☐ Finish ☐ Misread ☐ Turning Sequence ☐							
OTHER: _____									

